

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

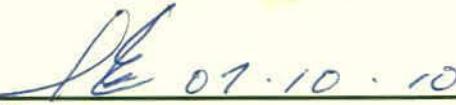
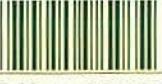
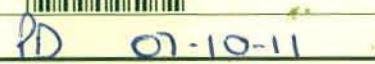
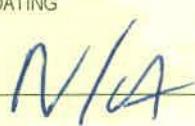
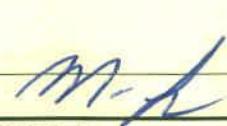
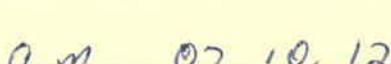
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & Initial all entries

Date: Monday, 9/10/2007 1:18:58 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: ARM
Job Number: 34475		Part Number: D3560042
Job Number:		
Seq. #:	Machine Or Operation:	Description :
6.0	D35921	PLATE
		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s) PLATE 334260		 07.10.10 5
7.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
		
Comment: LARGE FABRICATION RESOURCE 1		
1-Weld assembly as per dwg D3560		 07.10.10 5
8.0	QC5	INSPECT WORK TO CURRENT STEP
		
Comment: INSPECT WORK TO CURRENT STEP		 07.10.11 (5)
9.0	QC9	VISUAL WELDING INSPECTION
		
Comment: VISUAL WELDING INSPECTION		 07.10.11 (5)
10.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
		
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1		 07.10.11 (5)
11.0	POWDER COATING	POWDER COATING
		
Comment: POWDER COATING Powder Coat White Gloss (Ref. 4.3.5.1) as per QSI 005 4.3		 N/A
12.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
		
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		 07.10.11 (5)
13.0	PACKAGING 1	PACKAGING RESOURCE #1
		
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: WA		 07.10.12 (5)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 07/16/15
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 9/10/2007 1:18:58 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: ARM
Job Number: 34475		Part Number: D3560042
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
14.0	QC21	FINAL INSPECTION/W/O RELEASE
		 (5)
Comment: FINAL INSPECTION/W/O RELEASE 		

Job Completion





W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

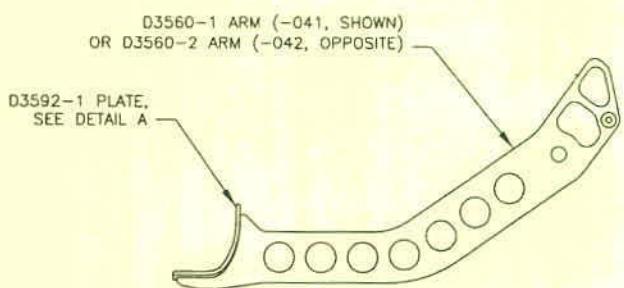
DART AEROSPACE LTD	Work Order:	34475
Description: Arm	Part Number:	D3560-2
Inspection Dwg: D3560	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

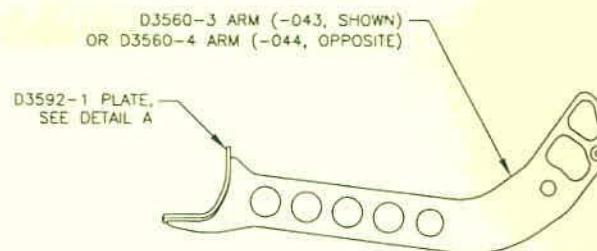
First Article Prototype

Measured by:	JL	Audited by:	SC	Prototype Approval:	N/A
Date:	07/09/21	Date:	07/09/21	Date:	N/A

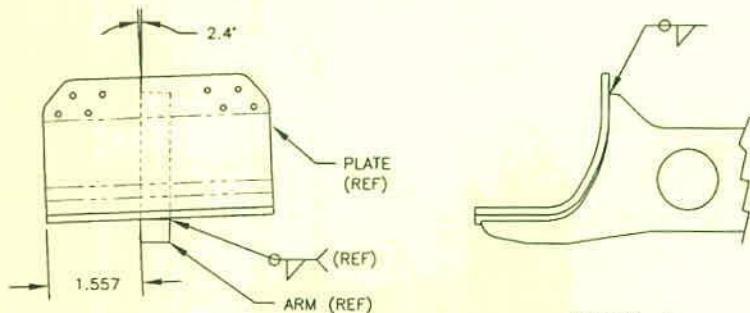
Rev	Date	Change	Revised by	Approved
A	07.01.17	New Issue	KJ/JLM	
B	07.06.13	Dimensions updated per Dwg Rev B	KJ/JLM	EE



D3560-041 ARM WELDMENT (SHOWN),
D3560-042 ARM WELDMENT (OPPOSITE)



D3560-043 ARM WELDMENT (SHOWN),
D3560-044 ARM WELDMENT (OPPOSITE)



DETAIL A
(SCALE 1:1)

GENERAL NOTES

- 1) WELD PER QSI 004
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

RELEASED
07.06.19

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DESIGN	DRAWN BY	DART	DART AEROSPACE LTD. HANMERSBURY, ONTARIO, CANADA
C	07.06.19	remove powder coat	
B	07.01.15	REDESIGN AS WELDMENT, ADD POCKETS	
A	06.09.25	NEW ISSUE	
CHECKED	APPROVED	DRAWING NO.	REV. C
		03560	SHEET 1 OF 3
DATE		TITLE	SCALE
07.06.19		ARM WELDMENT	1:1

NO. 34475

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WITHOUT NOTICE
WORK ORDER

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NO. 34475
WORK ORDER
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40.196 (DRILL #9 REF)
C-SINK 40.385x100

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DATE	CHECKED 4
DART	

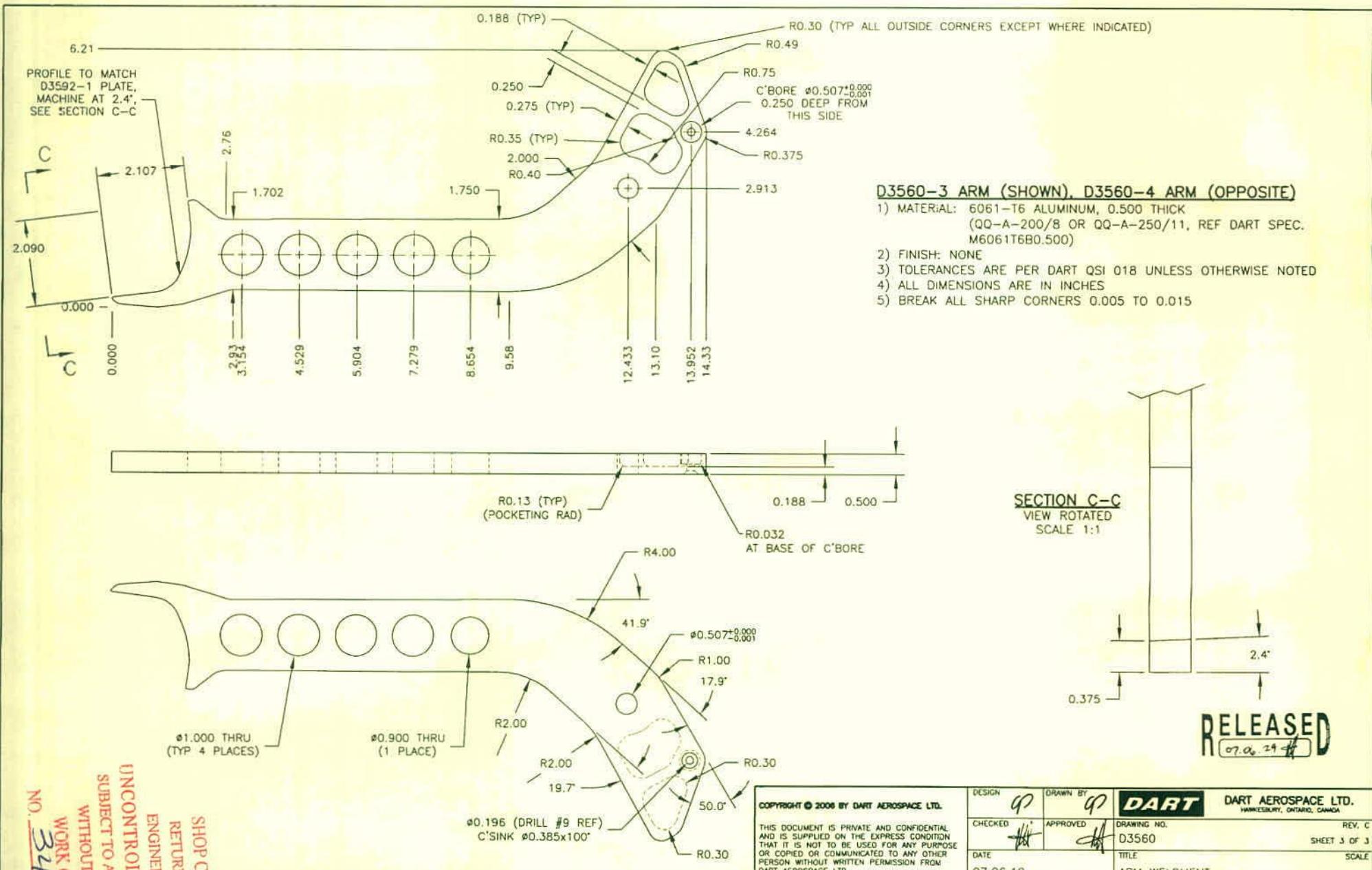
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DESIGN CHECKED <i>H</i>	DRAWN BY APPROVED <i>H</i>	DART	
DRAWING NO. D3560		DART Aerospace Ltd. Markham, Ontario, Canada	
DATE 07.06.19		REV. C SHEET 2 OF 3 SCALE 1:2	
TITLE ARM WELDMENT			

D3560-1 ARM (SHOWN), D3560-2 ARM (OPPOSITE)

- 1) MATERIAL: 6061-T6 ALUMINUM, 0.500 THICK
(QQ-A-200/8 OR QQ-A-250/11, REF DART SPEC.
M6061T6B0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP CORNERS 0.005 TO 0.015

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07.06.2014

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DESIGN	90
DRAWN BY	90
DART	
CHECKED	APPROVED
DRAWING NO.	
D3560	
SHEET 2 OF 3	
SCALE 1:2	
TITLE ARM WELDMENT	
REV. C	
DATE 07.06.19	
12	



NO. 34475

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